

Date: Monday, 27/04/2009 12:51:43 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 UTILITY-POD ACCESSORIES KIT
Job Number :	47539		
Estimate Number :	10244		
P.O. Number :		Part Number :	K10002
This Issue :	27/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	K10002 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	43865	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JUD 09.04.27	Due Date :	20/05/2009
Comment :	Est Rev: C 00.06.26 Revised per ECN 296, new dwg K10002 rev. A EC Est Rev: D 07.01.12 Rmv photocopy bluefile from seq. 1 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Handwritten: JUD 09/05/05



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10002 CHG 002

Handwritten: S 09/05/05

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D22301	Lug
-----	--------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2230-1

Lug

Handwritten: 46427

Handwritten: JUD 09/05/05 (2)

4.0	D22303	Lug
-----	--------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2230-3

Clamp

Handwritten: B46516

Handwritten: JUD 09/05/05 (2)

5.0	D2324	Strut
-----	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

Handwritten: 45886

Handwritten: JUD 09/05/05 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 UTILITY-POD ACCESSORIES KIT

Job Number: 47539

Part Number: K10002

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2324-1

Strut _____

6.0

D2523

Mounting Braket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2523

Mounting Bracket

33407

8809105/05 (x2)

7.0

D2524

Bracket Clamping



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2524

Side Plate

1336396

8809105/05 (x2)

8.0

AN37A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN3-7A

Bolt

M110704

8809105/05 (x2)

9.0

AN315A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3-15A

Bolt

M161780

8809105/05 (x2)

10.0

AN412A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-12A

Bolt

109754

8809105/05 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 UTILITY-POD ACCESSORIES KIT

Job Number: 47539

Part Number: K10002

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Qty Part Number

Description

Batch

8 AN4-13A

Bolt

M110731

12.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-16A

Bolt

108471

13.0

AN960JD10

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD10

Washer

M110985

14.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

26 AN960JD416

Washer

M110363

15.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L3

Nut (or MS21042-3)

M110844

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 UTILITY-POD ACCESSORIES KIT

Job Number: 47539

Part Number: K10002

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21042L4

Nut (or MS21042-4)

M110450

1 Document package from Step 2

S
②

8809/05/05 (2)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

501/05/05 (2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP k10002

Location: D

169/05/06 (2)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06

Job Completion



ME
09-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. K10002	REV. A SHEET 1 OF 1
DATE 00.06.01		TITLE HELI-UTILITY POD KIT	SCALE NTS
A	00.06.01	NEW ISSUE	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING HELI-UTILITY-POD INSTALLATIONS:

AIRCRAFT	INSTALLATION
AS350	D350-602-011 D350-602-012

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10002	D350-602-011 D350-602-012
D2230-1	4	4
D2230-3	4	4
D2324-1	1	1
D2523	2	2
D2524	2	2
AN3-7A	4	4
AN3-15A	8	8
AN4-12A	1	1
AN4-13A	8	8
AN4-16A	4	4
AN960JD10	24	24
AN960JD416	26	26
MS21042-3 (OR L3)	12	12
MS21042-4 (OR L4)	13	13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47539

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Work Order ID 53265

October 29, 2009 11:56:50 AM

Page 1

Item ID: K10002

Accept

Revision ID: A

Item Name: Pod Kit, 350

Start Date: 10/29/09 Start Qty: 2.00

Required Date: 10/30/09 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

K10002

Rev A

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

2 X K10002 B47539

ADD TO EACH KIT:

4 X D2856-400-720 B

PER NCR09-104

1 X D350-602-014 B52205

ADD TO K10002 KIT

4 X D2856-400-720 B

PER ECN09-104

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

9/10/09 3x sp

2/5 09/11/03

Work Order ID 53265

October 29, 2009 11:56:50 AM

Page 2

Item ID: K10002

Accept

Revision ID: A

Item Name: Pod Kit, 350

Start Date: 10/29/09 Start Qty: 2.00

Required Date: 10/30/09 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP'S

9/11/03 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ADD A COPY OF THOS W/O WITH EACH OF ABOVE

09/11/03

u 09-11-03

Picklist Print

October 29, 2009 11:56:49 AM

Page 1

Work Order ID: 53265

Parent Item: K10002RevA

Parent Item Name: Pod Kit, 350

Start Date: 10/29/09

Required Date: 10/30/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2856-400RevA		Manufactured	No			110	f	376.2237	4.8000			



Abraison Strip



9/10/09 (2x) SL

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST403	376.2236842	
50593	160.223684	
52563	216	

4x3=12

(D2856-400-720) cut (4) at 7.20" as per dwg and inspect ***Per Kit***

WAS
8/21/09

List Lots

Page 1 of 1

October 29, 2009 11:43:09 AM

Criteria : Item ID: K10002RevA All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		

K10002RevA	Main Warehouse	47539		2.0000	QC21	CHG002	
Pod Kit, 350	FG						

Total:

2.0000

9/10/09 54 (2x)

List Lots

Page 1 of 1

October 29, 2009 11:44:14 AM

Criteria : Item ID: D350-602-014RevF3/A/H All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D350-602-014RevF3/A/H	Main Warehouse	52205	10/02/09	1.0000	QC21	CHG001	
Heli-Utility-Pod, RH	1						
Total:				1.0000			

tx 9/10/09 self